



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

Done
D350-636-012
Job Sheet 169857



Part No: D350-636-012

Job Qty: 1 ea

Part Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/2/18

Job Tracking No:

Due Date: 1/26/18

Created By: Mario Poulin

Type: SOLD

Description:

Customer: Heli-Fix Maintenance Inc (CHFIX01)

252 Edouard Drouin St Jerome, QC, J7Y 4X5 Canada ph:(450) 712-3955

Note: DWG D3492 REV E SHEET 1, D2750-042 REV G SHEETS 1,2,5,9 IPP Rev:I 02.09.25 IPP Rev:J 06-03-23 As per Rev D IPP Rev:K 06-07.13 As per dsi9343 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verf:EC IPP Rev:M 08-04-22 DD verified:EC IPP Rev:N 08-09-23 revF DD verified:ec IPP Rev:O 09-02-06 per PAR09-010 DD verf:EC IPP Rev:P 10.06.22 revise seq110 DD verf:EC IPP Rev:Q 10.10.01 as per IIN revH DDverf:EC IPP REV:R 13.08.27 PER ECN13-594 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		1/25/18	0.00	0.00	Start Up Skid tubes-1		
110	Skid tubes	1 pcs		1/25/18	0.00	4.36	Skid tubes-4		<i>JY BE</i>
120	QC	1 pcs		1/25/18	0.00	0.00	QC10		
130	QC	1 pcs		1/25/18	0.00	0.00	QC5		
140	HandFinish	1 pcs		1/25/18	0.00	0.91	HandFinish1		<i>24-18-1-12</i>
150	QC	1 pcs		1/25/18	0.00	0.00	QC7-2		<i>2018/01/15 JY</i>
160	Skid tubes	1 pcs		1/25/18	0.00	4.36	Skid tubes-1		<i>BE</i>
170	QC	1 pcs		1/25/18	0.00	0.00	QC10		<i>BE, MC #7 MLC</i>
180	QC	1 pcs		1/25/18	0.00	0.00	QC5		
190	HandFinish	1 pcs		1/25/18	0.00	0.91	HandFinish2		<i>2018/01/22 JY</i>
200	SprayPaint	1 pcs		1/25/18	0.00	0.69	Spray Paint		<i>D.I. 18-01-30</i>
210	QC	1 pcs		1/25/18	0.00	0.00	QC14		<i>BE 18-01-31</i>
230	HandFinish	1 pcs		1/26/18	0.00	0.91	HandFinish4		<i>BE 18-02-02</i>
240	QC	1 pcs		1/26/18	0.00	0.00	QC5		
250	Packaging	1 pcs		1/26/18	0.00	0.00	Packaging1-3		<i>9-89</i>
260	QC	1 pcs		1/26/18	0.00	0.00	QC4		<i>FEB 06 2018</i>
265	DC	1 pcs		1/26/18	0.00	0.00	DC		<i>W. AL</i>
270	Packaging	1 pcs		1/26/18	0.00	0.00	Packaging3-1		
280	QC21-FG	1 Ea		1/26/18	0.00	0.00	QC21		

Part Op 110 - 1- Pick D2600-3 Bent Drill pilot holes as per Dwg D2750 sheet 4 (D2750-2 details). Drill using drill Jig DT8150 & Descriptions: DT8863A for second side only DT8863B for first side (detail K) 4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting. Open to 0.500" using hole saw. VERIFY AND RECORD FWD BEND ANGLE. 6- Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297". 7- Open up holes of Detail J to 0.297" (total of 2 holes per side) 8- Weld D2744 Cap as per Dwg D2750 and QSI.004. Fill grooves in bend left from bending as per QSI 004 9- Grind welds flush as per Dwg D2750 *AKM136158/138673 & R*
160 - 1- Open up holes of Detail L using hole saw and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750. 2- Open up holes of Detail K using hole saw to 0.750" (total of 4 holes per side) 3- Open float holes using uni-bit to .500" (4 per Side) 4- Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9) 5- Deburr and blow out all chips from inside of tube 7- Bond web D2739 in place as per QSI 015, let cure for

S031720 x 1 x RH

F9072

27.7°

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EXP 18-04-21

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S031720

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**Skidtube RH, Std Wearplates, DART (Apical)
Cylindrical/Aerazur Float Comp.**

PART NO: D350-636-012

Revision:

Operation: Start up Operation

Change No: CHG007

Mfg Date: 01/12/18

Job No: 169857

12hrs.

180 - ***VERIFY C'BOARD IS GOOD***

190 - Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

200 - 1- PRIME AS PER DWG AND QSI 005 4.2

210 - Inspect for foreign object per QSI 024

230 - 1-Install inserts as per dwg D2750 2-Inspect for Foreign Objects 3-Install blade fitting D3488-042, wearshoes and ground handling hardware as per dwg D2750 5-Coat all exposed fasteners with "LPS Procyon" batch: 1133690

265 - record fwd angle: 89.9° Photocopy blue file and type labels per PPP D350-636-012 CHG 007

270 - Package as per PPP D350-636-012

-200 Primer 137670 White paint: 138686

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D2600-3-BENT-RH <u>5030354</u>	1	0	0	0
	D2744 <u>5003318</u>	1	18	0	0
160-Skidtubes	D2739 <u>3165489</u>	1	14	0	0
	D2743 <u>5026588</u>	8	288	0	0
	D3490-1 <u>5017322</u>	4	112	0	0
	D3490-3 <u>5030890</u>	4	17	0	0
230-HandFinish	ALS4-1032-225 <u>5007280</u>	38	1,680	0	0
	AN3C5A <u>5019396</u>	34	1,592	0	0
	AN3C6A <u>5019397</u>	4	277	0	0
	AN6C44A <u>FM137055-1</u>	4	521	0	0
	AN8C35A <u>FM137203</u>	1	96	0	0
	D2745 <u>5000390</u>	8	238	0	0
	D3488-042 <u>F163297-2</u>	1	11	0	0
	D3492-1 <u>5025647</u>	8	248	0	0
	D3492-3 <u>F165369</u>	8	239	0	0
	D3535-25 <u>5032628</u>	1	10	0	0
	D3536-25 <u>5031897</u>	1	13	0	0
	-D3537-1 <u>5037413</u>	3	95	0	0
	D3631-1 <u>5008168</u>	8	212	0	0
	D3791-1 <u>5024390</u>	1	28	0	0
	D3793-1 <u>F159874</u>	1	8	0	0
	-D3793-3 <u>5032647</u>	1	9	0	0
	D3794-1 <u>5031919</u>	1	4	0	0
	D3794-3 <u>5032222</u>	1	7	0	0
	MS21043-6 <u>5016883</u>	4	94	0	0
	MS21083C8 <u>5034401</u>	1	91	0	0
	NAS1149C0332R <u>5019380-1</u>	38	5,228	0	0
	NAS1149C0832R <u>FM1355360</u>	1	113	0	0
	NAS1515H3L <u>FM137361-25</u>	4	170	0	0
	NAS1611-010 <u>FM138441-2</u>	8	434	0	0
	NAS1611-013 <u>5022099</u>	8	305	0	0
250-Packaging	AN8C21A	2	223	0	0
	D2741	1	40	0	0
	D3493-1	2	32	0	0
	D3532-1	2	5	0	0
	MS21083C8	2	91	0	0
	NAS1149D0863J	2	199	0	0

Part Specifications

Specifications could not be found.

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QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH: ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2
OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
FINISH WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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G	CORRECTED TOLERANCE ON $\phi 0.500$ THRU HOLE: IS $+0.010/-0.000$, WAS $+0.100/-0.000$ (ZN B3-4, B2-5); ADD VIEW TO CONTROL FWD BEND ORIENTATION (ZN D-1-4/-5/-6/-7); UPDATED FINISH OPTIONS; INSIDE OF TUBE NO LONGER SPRAYED WITH LPS-3. REASON: PAR13-276 AND NCR13-2757	MB	13.07.11
F	INCORPORATE DSI 9413; QTY (3) D3337-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-1/-3 (ZN C8-1); D3794-1/-3 REPLACES D3535-1/-3 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWDRAFT SADDLE REMOVED (B PL); WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24894-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	MM		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	13.07.11		

DART AEROSPACE USA, INC.

KENT, WA

DRAWING NO.

D2750

REV. G

SHEET 1 OF 11

TITLE

350 SKIDTUBE ASSEMBLY

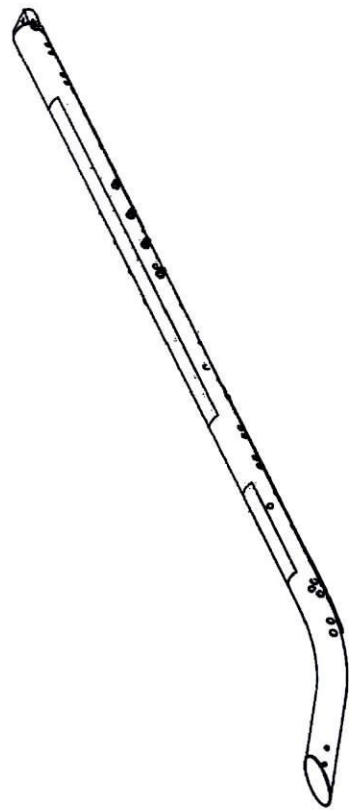
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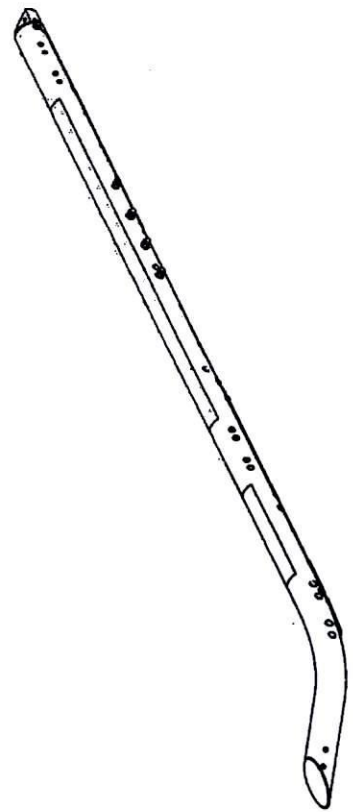
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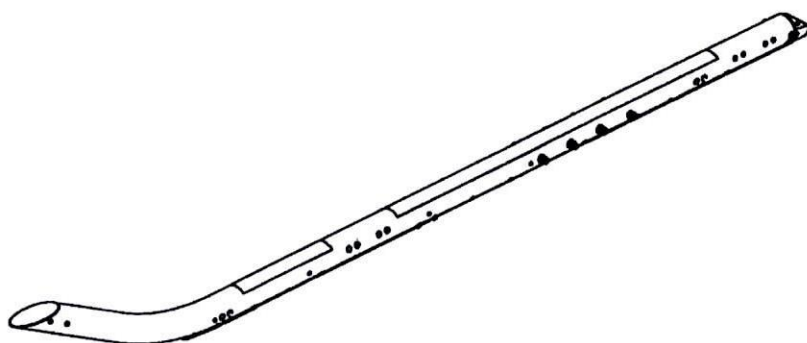
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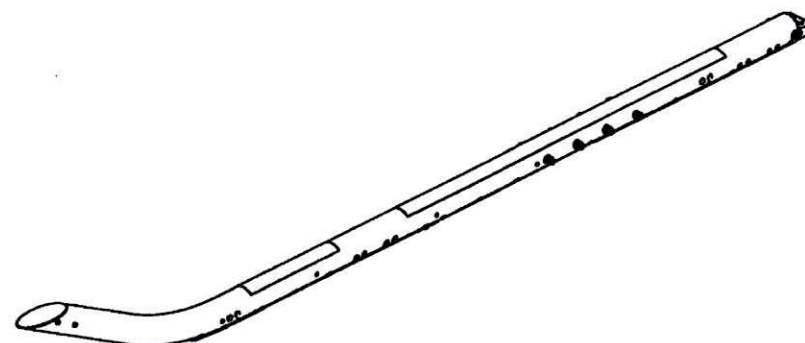
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MFG. APPR.		REV. G SHEET 2 OF 11
APPROVED	M	TITLE 350 SKIDTUBE ASSEMBLY
DATE	13.07.11	SCALE NTS
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D2750-043 350 SKIDTUBE ASSEMBLY, LH

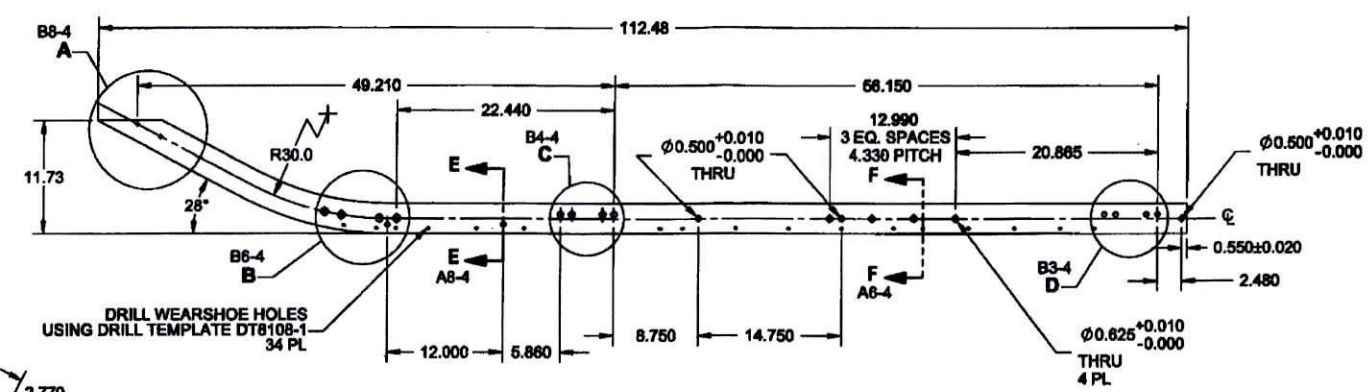


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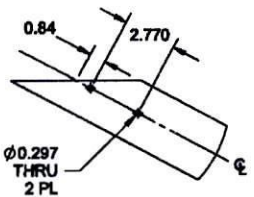
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MFG. APPR.	<i>[Signature]</i>	SHEET 3 OF 11	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	350 SKIDTUBE ASSEMBLY	NTS
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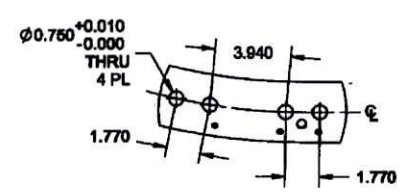
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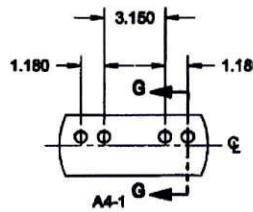
D2750-1 LH SKIDTUBE



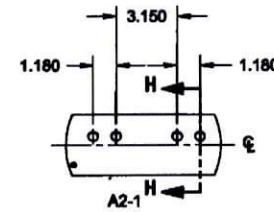
DETAIL A
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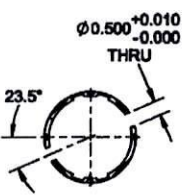
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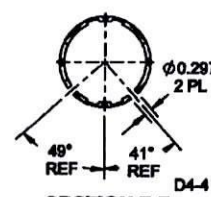
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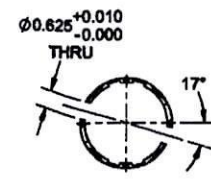
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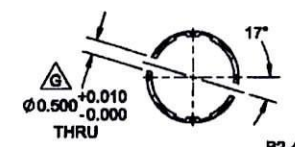
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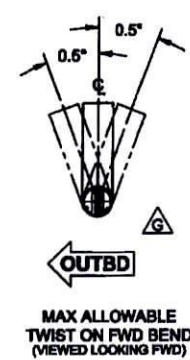
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SECTION G-G
SCALE 3X, 4 PL



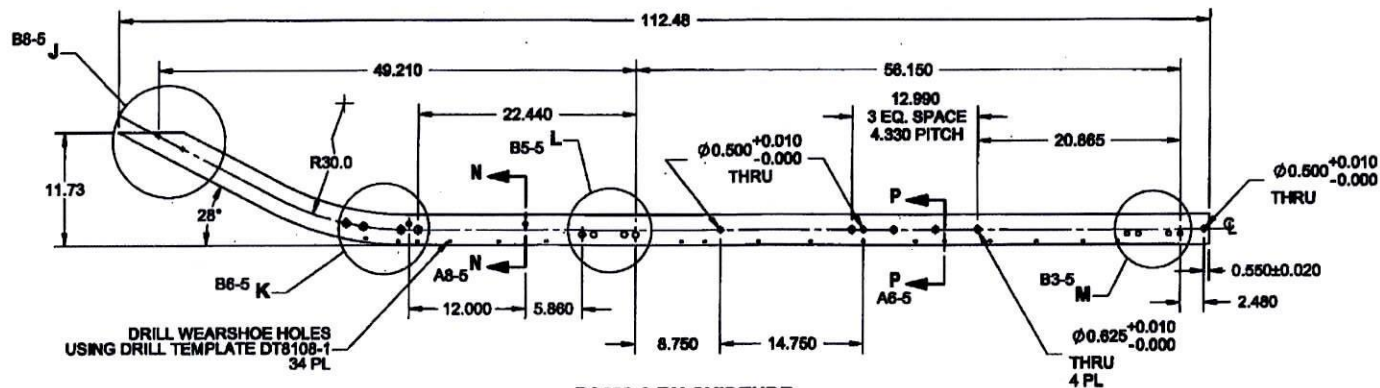
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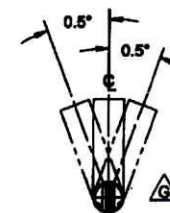
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CHECKED		DRAWING NO. D2750	REV. G
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APPROVED		TITLE 350 SKIDTUBE ASSEMBLY	SCALE
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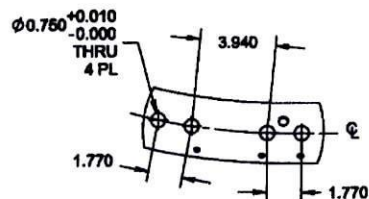
D2750-2 RH SKIDTUBE



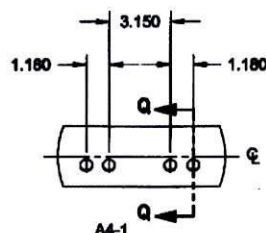
OUTBD
MAX ALLOWABLE
TWIST ON FWD BEND
(VIEWED LOOKING FWD)



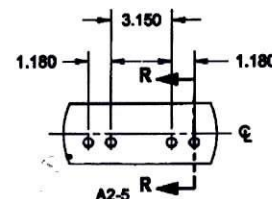
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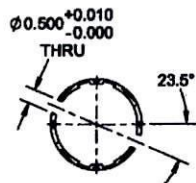
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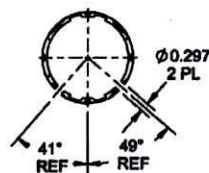
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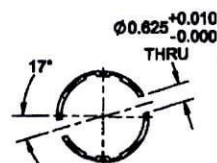
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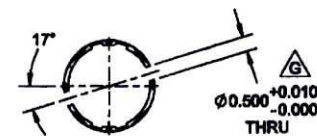
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SECTION P-P
SCALE 3X, 17 PL



SECTION Q-Q
SCALE 3X, 4 PL



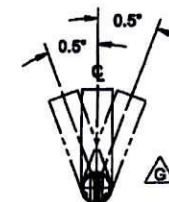
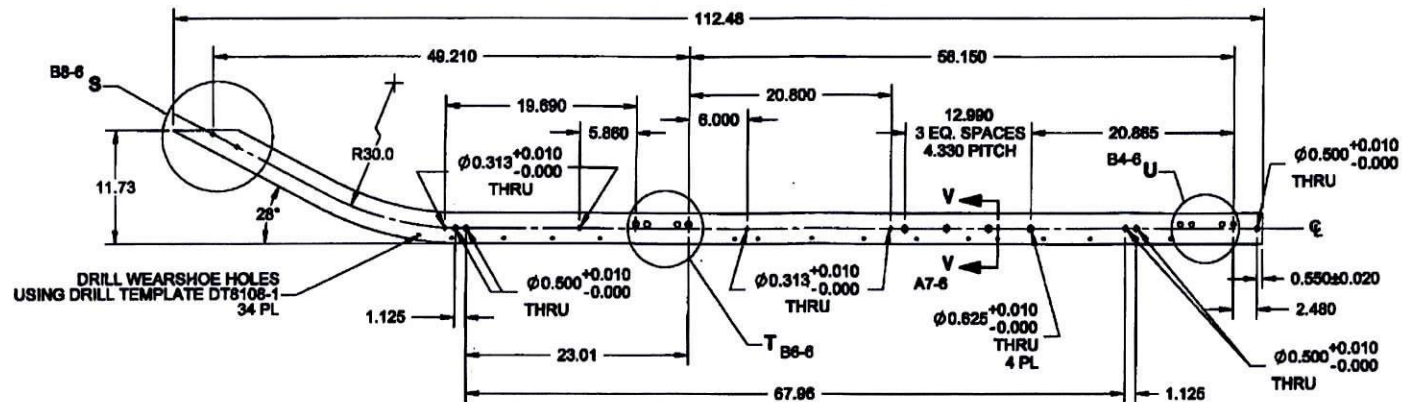
SECTION R-R
SCALE 3X, 4 PL

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APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	
DATE	13.07.11	NTS	

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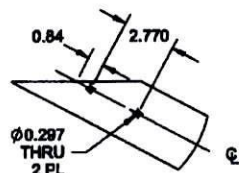
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8 7 6 5 4 3 2 1

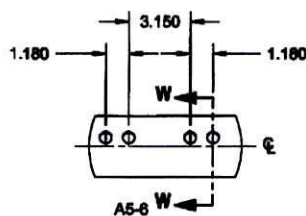


OUTBD
MAX ALLOWABLE
TWIST ON FWD BEND
(VIEWED LOOKING FWD)

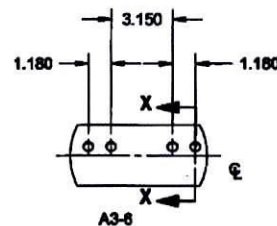
D2750-3 LH SKIDTUBE



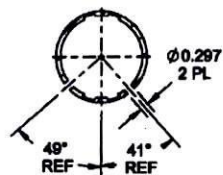
DETAIL S
SCALE 2X



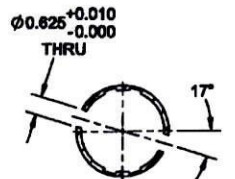
DETAIL T
SCALE 2X



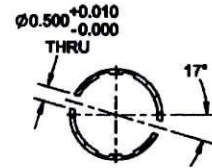
DETAIL U
SCALE 2X



SECTION V-V
SCALE 3X, 17 PL



SECTION W-W
SCALE 3X, 4 PL

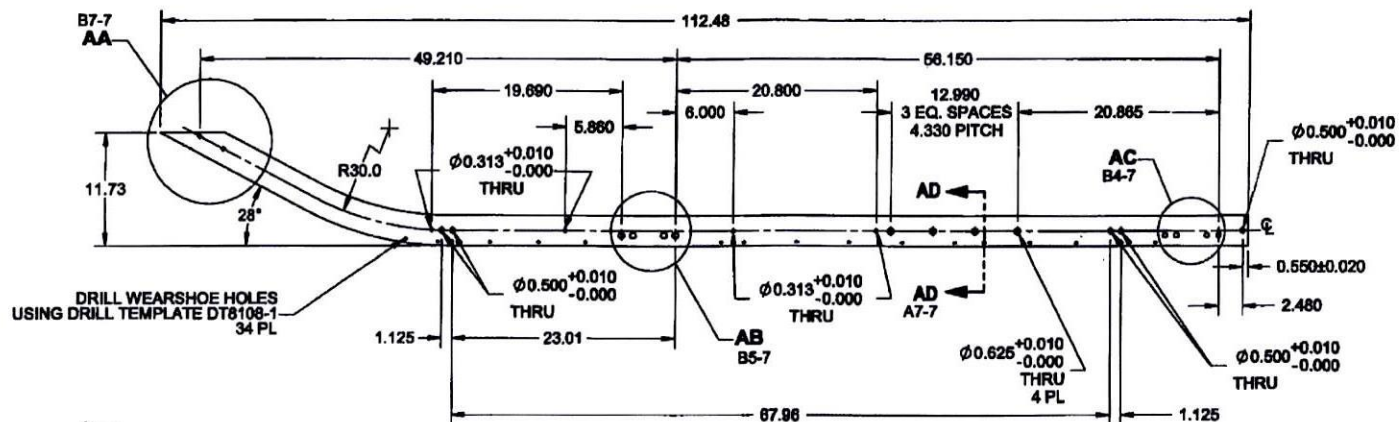


SECTION X-X
SCALE 3X, 4 PL

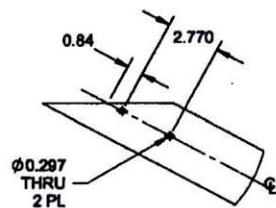
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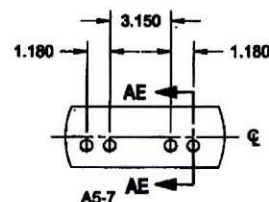
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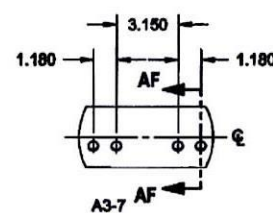
D2750-4 RH SKIDTUBE



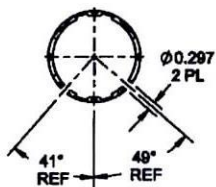
DETAIL AA
SCALE 2X



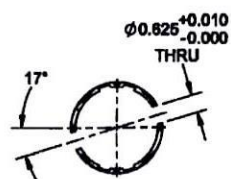
DETAIL AB
SCALE 2X



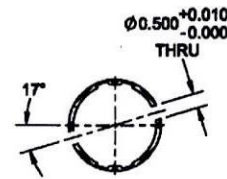
DETAIL AC
SCALE 2X



SECTION AD-AD
SCALE 3X, 17 PL



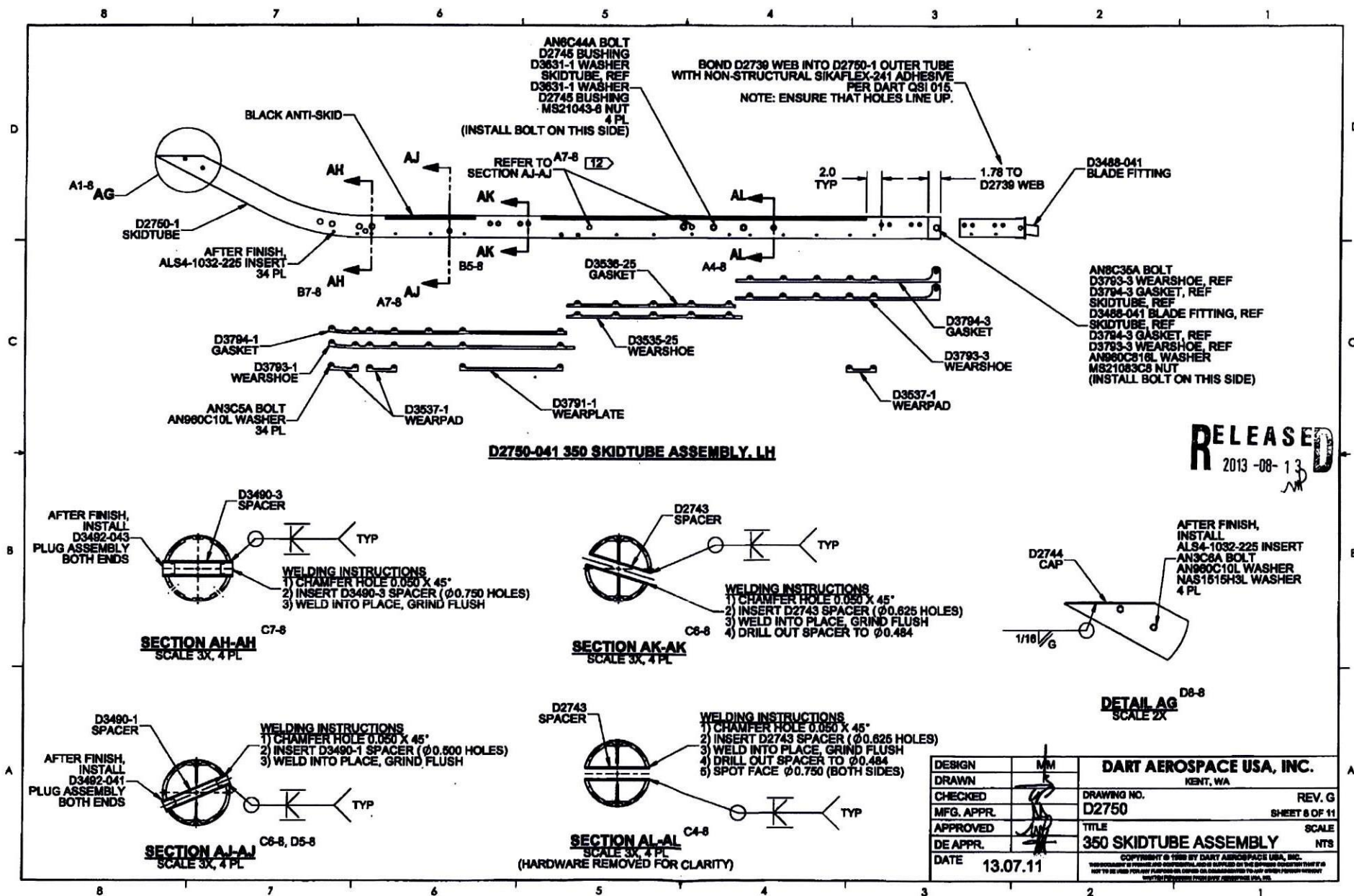
SECTION AE-AE
SCALE 3X, 4 PL

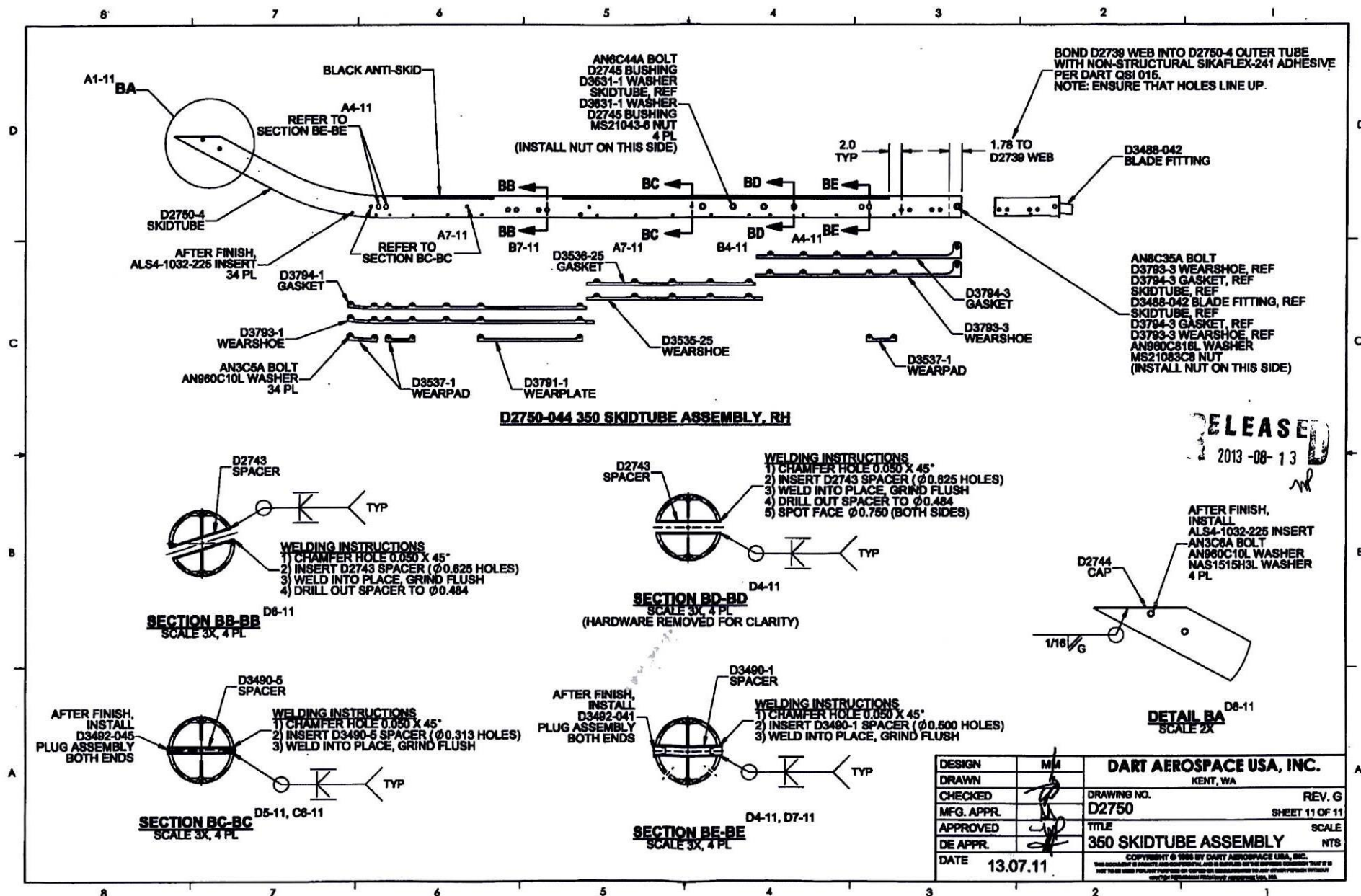


SECTION AF-AF
SCALE 3X, 4 PL

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Hawkesbury, ON
K6A 1K7
Canada

Master Unit 000468

Tel (613) 632-5200

Containers on Master Unit 000468				
Serial No	Part No	Customer Part No	Status	Quantity
S038719	AN8C21A	AN8C21A	Allocated	2
S038718	D2741	D2741	Allocated	1
S038717	D3493-1		Allocated	2
S038716	D3532-1		Allocated	2
S038715	MS21083C8	MS21083C8	Allocated	2
S038714	NAS1149D0863J	NAS1149D0863J	Allocated	2